Page 1

Sunday, May 02, 2010 1:11:46 PM D4016-3 Item ID: Accept Setup Start **Revision ID:** Stop Hinge Half, Lid Item Name: **Start Date:** 5/3/2010 **Start Oty: 12.00 Cust Item ID:** Required Date: 5/7/2010 Req'd Oty: 12.00 **Customer:** Reference: Run Start Mr Date: 10-5- 2 Tooling: Process Plan: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Reject Draw Plan Accept Reject Insp. Work Center ID Description Run Hours Qty Number Rev. Code Oty Number Stamp Draw Nbr **Revision Nbr** D4016 Α 100 Cut blanks as per folio 0.00 onl 10/05/08 Bandsaw Memo Jeaspa Bandsaw CUT BLANK as per folio 110 0.00 12 6 HAAS I MACHINE AS PER FOLIO FA874 AND DWG WL 10/05/09
FOLIO REV: AA HAAS CNC vertical machine #1 DWG REV:

DEBURR

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	By Date Qty			Approval QC Inspector
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Part No.	•	PAR #:	Fault Catoo	lorv:	NCP: Voc	No. DO	A .	Dete	
1 411 110		•			QA: N/C Closed: Date:				
NCR:		T		R NON-CONFORMA					
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	🔽 Secti	on C	Chief Eng	QC Inspector
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Work Order ID 58243

Sunday, May 02, 2010 1:11:46 PM



Page 2

Item ID:

D4016-3

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 5/7/2010

Hinge Half, Lid

5/3/2010

Start Oty: 12.00 Reg'd Otv: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: ___ Date: Tooling:

0.00

SPC (Y/N):

Date:

Date:

Start Stop

12 8

Sequence ID/

Work Center ID

120

Quality Control

Operation Description

QC2-Inspect parts off machine FAI/FAIB

Memo

QC: ____ Date:

Set Up/ Run Hours

0.00 Cml 100s/09

Draw Number Draw Rev.

Plan Accept Code Qty

Reject Qty

Run

Reject Insp. Number

Stamp

130

OC

Quality Control

OC8- Inspect parts - second check

Memo

0.00

0.00

160

Packaging Packaging

Identify as per dwg & Stock Location: //

Memo

0.00

0.00

Dart Aerospace I	Ltd
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W/O:		1	V	VORK ORDER CHA	NGES		•		
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DATE	STEP	Description of	NC Initial		Section B			Approval	
		Section A	Chief Eng	Action Description Chief Eng	on Sign & Date	Section C	Chief Eng	QC Inspector	
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Work Order ID 58243

Sunday, May 02, 2010 1:11:46 PM



Page 3

Item ID:

D4016-3

Accept

Date:

Draw

Rev.

Plan

Code

Setup Start

Stop



Revision ID:

Item Name:

Start Date:

Hinge Half, Lid

5/3/2010

Start Qty: 12.00

Required Date: 5/7/2010

Req'd Qty: 12.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Operation

Description

Date: _____

QC21- Final Inspection - Work Order Release

Date: _____ Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:_

Accept

Qty

Stop

Reject

Qty



Sequence ID/ Work Center ID

170

Quality Control

Memo

Run

Start



Insp.

0.00

0.00

Number Stamp

Reject

BS 10-5-10

-4.170	·ospacc	- 14							
W/O:		f	WC	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date:	
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NCR:		1	WORK ORDI	ER NON-CONFORM	ANCE (NCI	₹)			
DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Section		Chief Eng	QC Inspector
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Picklist Print

Sunday, May 02, 2010 1:11:45 PM

Work Order ID: 58243

D4016-3 Parent Item:

Parent Item Name:

Hinge Half, Lid

Comments:

I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD

per dwg REV.A DD 10.02.22 verified by:EC

IPP Rev:B as

Start Date: 5/3/2010

Required Date: 5/7/2010

Start Oty: 12.00

0.08

Required Oty: 12.00

Component Item ID/

Item Name M304B1.000X1.000 Replacement Mfg/ Item ID Purch Purchased

Bin Primary Item Location No

Last Location Route Seq ID 100

Unit of Measure Hand f

Qty on Qty per Kit

Qty Issued Date Status

Page 1

Issued



304 bar 1.00 x 1.00

Location

MAT54 113290

18.9894737

Loc Oty

18.98947368

Loc Code

18.9895

1.0153 and 10/05/08

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W/O:			WO	RK ORDER CHANG	ES				
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		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	
	Re	solution:	Disposition	•	_ QA: N/C (Closed:	·	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign		cation	Approval Chief Eng	Approval QC Inspector
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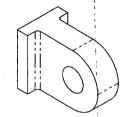
DART AEROSPACE LTD	Work Order: 58243
Description: HINGE HALF LID	Part Number: 174011,-3
Inspection Dwg: \(\) \(\frac{1}{2} \) \(\frac{1} \) \(\frac{1} \) \(\frac{1}{2} \) \(\frac{1}{2}	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	:le	_ Proto	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.88	± 030	.877				
.13	±.03b	.125				
.250	- 0/0	.250				
R. 03	± 030	R.030				
.13	± 03b	,129				
.50	±-030	.500				
. 63	+.036	.626				
.563	+ 010	. 57,3				
Ø.257	+.006	Ø.258				
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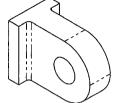
Measured by:	and	Audited by: MV=	Prototype Approval:	N/A
Date:	10/05/09	Date: 10/05/09	Date:	N/A

:	Rev	Date	Change	,	Revised by	Approved
	A		New Issue		KJ/JLM	



D4016-3 HINGE HALF, LID

D4016-1 HINGE HALF, BASE



D4016-5 HINGE HALF, LIGHT LID

RELEASED 2010 -02- 16

Α	NEW ISS	;UE		JPH	10.01.29			
REV.			DESCRIPTION	BY	DATE			
DESIGN	١	AJS	DART AFF	ROSPACE L	TD			
DRAWN	١	AJS	HAWKESBURY	, ONTARIO, CANA				
CHECK	.ED	0	(C) DRAWING NO.		REV. A			
MFG. A	PPR.	7	D4016		SHEET 1 OF 2			
APPRO	VED	140	TITLE		SCALE			
	DE APPR.		BASKET HINGE					
DATE	10.0	1.29	THIS DOCUMENT IS PRINATE AND CONFIDENTIAL NOT TO BE USED FOR ANY PURPOSE OR COPE	D BY DART AEROSPACE AL AND IS SUPPLED ON THE EXPRES TED DR CONSUMICATED TO ANY OT THE PROMISE AREASE ACELLTS.	AS CONDITION THAT IT IS			

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGE	<u>S</u>			-	
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	By Date Qty Approx Chief En			Approval QC Inspector
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	Res	solution:	Disposition	:	QA: N/C CI	osed: Date:			
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCF	3)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
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GRAIN DIRECTION 0.13 0.250 0.50 R0.03 0.38+0.03 R0.38 REF 0.13 Ø0.257 THRU R0.31 - 0.563 REF GRAIN DIRECTION 88.0 0.63 0.50 0.13 Ø0.257 THRU R0.03 0.75 -D4016-3 HINGE HALF, LID **D4016-1 HINGE HALF, BASE D4016-5 HINGE HALF, LIGHT LID** NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B -5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 DESIGN DART AEROSPACE LTD REF DART SPEC M6061T6B REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs DRAWN AJS HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4016 MFG. APPR. SHEET 2 OF 2 TITLE APPROVED SCALE **BASKET HINGE** DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD

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	WORK ORDER (WORK ORDER CHANGES						
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	· 1							
	STEP	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr		

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP	Description of NC		Corrective Action Section B			Verification	Annuoval	A			
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